

Work Order ID 155375***155375***

Page 1

Thursday, January 12, 2017 3:41:07 PM

Item ID: 647.4210

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket LH

Start Date: 1/17/2017 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 16.00

16

Customer:

Reference:

DAS

21

9-89

Approvals:

Process Plan:

Date: JAN 13 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.4200

N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 9.10"

7 φ PR-02-1

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.13

HAAS CNC vertical machine #1

1-Machine per folio FB305

DWG REV: N/C

FOLIO REV: AA

2- deburr and break all sharp edges

7 φ PR-02-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																												
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Work Order ID 155375

Thursday, January 12, 2017 3:41:07 PM

155375

Page 3

Item ID: 647.4210

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket LH

Start Date: 1/17/2017 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.05

Packaging

Mat'l Certs req'd.

7x 8017-03-9.

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.05

Quality Control

2.1 mils thickness primer

7
DAS
38
9-80
MAR 10 2017

180

Identify as per dwg & Stock Location C412

0.00

180

Packaging

Memo

0.03

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

7
DAS
6
9-80
MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 155375

Thursday, January 12, 2017 3:41:07 PM

155375

Page 4

Item ID: 647.4210 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket LH
Start Date: 1/17/2017 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 1/24/2017 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.27							
Quality Control									


MAR 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, January 12, 2017 3:41:06 PM

Page 1

Work Order ID: 155375

155375

Parent Item: 647.4210

647 4210

Parent Item Name: Bracket LH

Start Date: 1/17/2017

Required Date: 1/24/2017

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV A RQ 14/05/28 VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A1.250X1.00 X0.100X0.125		Purchased	No			100	f	19.0000	0.758	12.76632			

***M7075T6A1 250X1 00X0 100X**

7075T6 ANGLE 1.25" X 1.00" X .100W" X .125R

Location

Loc Qty

Loc Code

MAT051

19

m129809

19

5.833 P17-02-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02865				SHEET 1 OF 1	
	DWG NO. 647.4200	REV: N/C	PREPARED BY R. ROSANO	DATE: 05/05/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
APPROVED BY: ENGR <i>[Signature]</i>		MDR <i>[Signature]</i>		EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: CHANGED PRETREATMENT CALLOUT, MODIFIED VIEWS, ADDED VIEW FOR CUT				

SHEET 1, ZONE A1 IS:

NOTES: UNLESS OTHERWISE SPECIFIED

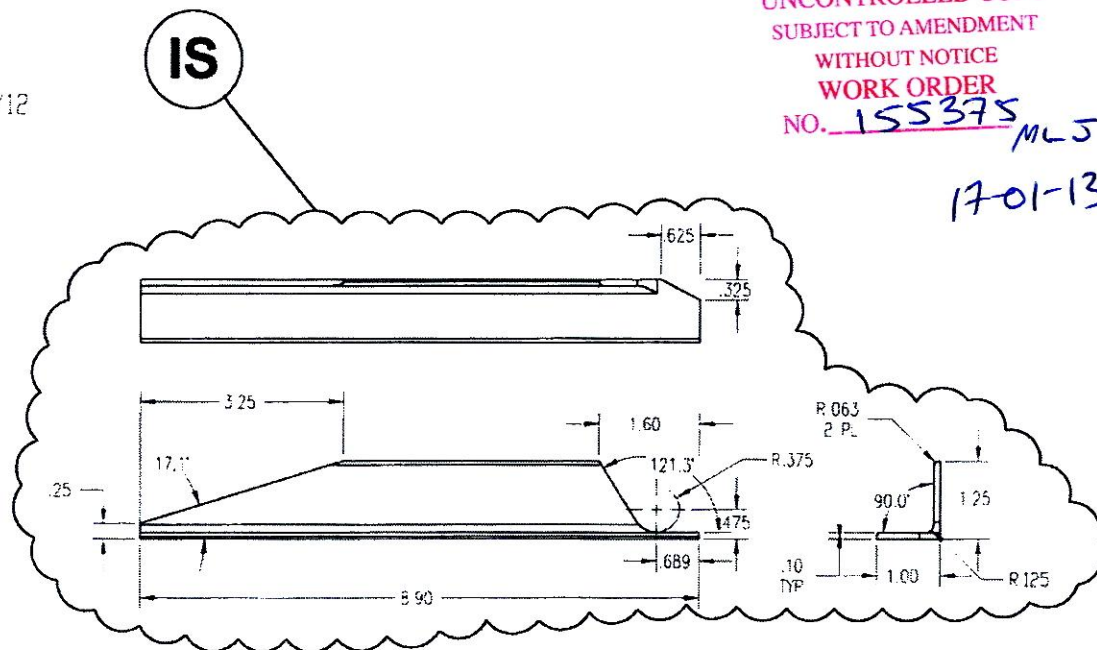
1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

2 FINISH: HARD ANODIZE 1AW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PR-148 ADHESION PROMOTER
PRIME 1AW MIL-P-23377 TYPE 1 CLASS N

3. DEBURR AND BREAK ALL SHARP EDGES

4. IDENTIFY 1AW MPP-120

SHEET 1, ZONE C1-C6 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 155375 MLJ

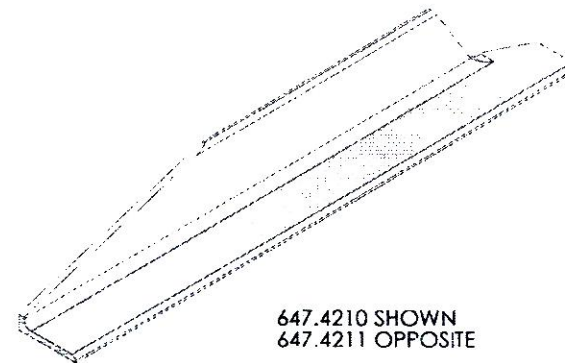
1701-13

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

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NOTES: UNLESS OTHERWISE SPECIFIED

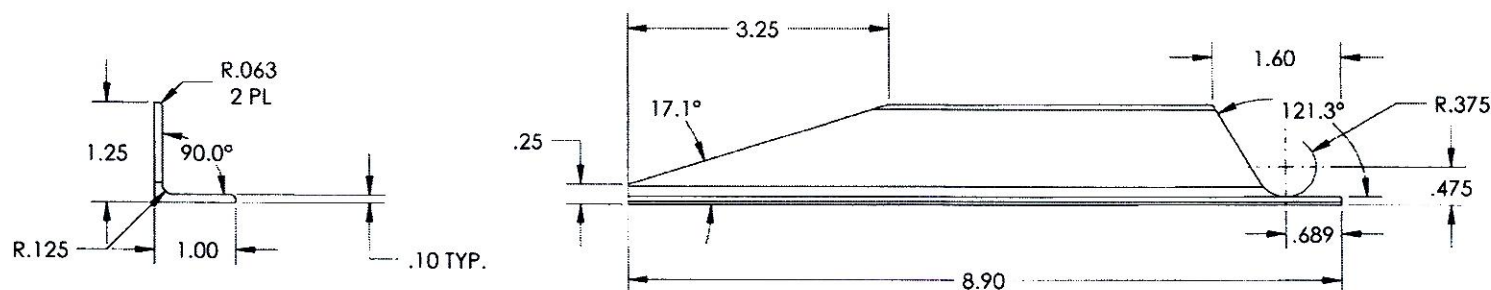
1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.4210 SHOWN
647.4211 OPPOSITE

UNINCORPORATED ECN(s)

028165



QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
1	3	647.4211	BRACKET RH		
1	2	647.4210	BRACKET LH		
1	1	647.4212	PLATE		
PARTS LIST					
NEXT ASSY (S)			APICAL INDUSTRIES		
111 310			2608 TEMPLE HEIGHTS DR		
			OCEANSIDE, CA. 92056 3512 (760)724-5300		
			BRACKETS		
			DATE CODE CODE	DATE INC.	REV.
			B 07M26	647.4200	M.C.
			SCALE NONE	SHEET 1 OF 2	

1 2 3 4 5 6 7 8

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A

B

C

D

647.4212

.125

.719

R.125

2.70

ORIGINAL DATE JANUARY 1980	DESIGNED BY J. H. H. H.	CHECKED BY J. H. H. H.
DRAWN BY J. H. H. H.		
REVISIONS APPROVED BY J. H. H. H.		
DATE		
SCALE		
SHEET 2 OF 2		

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEASIDE, CA. 92056-3512 (760) 724-5300

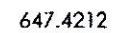
BRACKETS

SIZE 1/4" X 1/2" X 1/4" 180

B 07442 647.4200

SCALE NONE

REV. N/C



- 2.70

ORDER NO. 00000000 QUOTE NO. 00000000 BY 00000000 DATE 00/00/00 PROJECT 00000000 DRAWING 00000000	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEAN SIDE, CA 92056-3512 (760)724-5200
UNIT PRICE QUANTITY TOTAL TAX TOTAL	BRACKETS SIZE 1/2" X 1/2" X 1/2" 6061 ALU. 647.4200 SCALE NONE SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35353**

Purchase Order Date 2/17/2017

PO Print Date 2/22/2017

Page Number 4 of 6

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$69.30

10	154814	647.3915 DEFLECTOR REV. C	3/7/2017	8.00	\$35.00	\$280.00
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Yes

2/7/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total: \$280.00

11	154810	647.3916 DEFLECTOR REV. C	3/7/2017	6.00	\$18.10	\$108.60
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Yes

2/7/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total: \$108.60

12	155375	647.4210 BRACKET REV. N/C	3/7/2017
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Yes

2/7/2017

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

7.00

\$7.90

\$55.30

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

2/22/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913024

Date: 08-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
10 ea	Part: 646.3713 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20720	Rev: A PO: PO35353	Line: 1
8 ea	Part: 647.3915 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20729	Rev: C PO: PO35353	Line: 10
6 ea	Part: 647.3916 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20730	Rev: C PO: PO35353	Line: 11
7 ea	Part: 647.4210 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20731	Rev: N/C PO: PO35353	Line: 12
7 ea	Part: 647.4211 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20732	Rev: N/C PO: PO35353	Line: 13
20	Part: 650.9201	Rev: A	

SP17-03-9



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913024

Date: 08-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
10 ea	Part: 647.0110 Roof Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20726 PO: PO35353	Rev: A Line: 7	
4 ea	Part: 647.1712 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20727 PO: PO35353	Rev: E Line: 8	
6 ea	Part: 647.3914 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20728 PO: PO35353	Rev: C Line: 9	
DATE: 03/03/2017			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: 501703-9			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			